

Lupol® HG3100

Polypropylene

LG Chem Ltd.

Message:

Description

High Gloss

Application

Electrical & Electronic Parts

General Information			
UL YellowCard	E67171-248645		
Filler / Reinforcement	Mineral filler, 10% filler by weight		
Features	Highlight		
Uses	Electrical/Electronic Applications		
	Electrical components		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.00	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4 - 1.8	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	33.3	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	50	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1370	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	42.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ⁵ (23°C)	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.20 mm)	120	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	< 0.010	%	
Rear Temperature	190 - 210	°C	
Middle Temperature	200 - 230	°C	
Front Temperature	200 - 230	°C	
Nozzle Temperature	210 - 230	°C	
Processing (Melt) Temp	200 - 230	°C	

Mold Temperature	40.0 - 60.0	°C
Back Pressure	29.4 - 58.8	MPa
Screw Speed	30 - 60	rpm

Injection instructions

Secondary Injection Pressure: 20 to 100 kg/cm²

NOTE

1.	5.0 mm/min
2.	5.0 mm/min
3.	1.3 mm/min
4.	1.3 mm/min
5.	6.4mm notch depth

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

